

**\*84355\***

Page 1

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 10/05/2012    **Start Qty:** 4.00

**\*4\***

**Cust Item ID:**

**Required Date:** 24/05/2012      **Req'd Qty:** 4.00

**\*4\***

**Customer:**

**Reference:**

Approvals: Process Plan: ML5 Date: 12/05/10 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run	Start	*NR1*
	Stop	*NR2*

Draw Nbr	Revision Nbr
D4462	B

0.00

**\*100\***

## Waterjet

## FLOW CNC Waterjet

6661. 655

## Memo

Cut as per dwg

Prog rev:

Dwg rev: \_\_\_\_\_

0.00,

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

## Quality Control

## Memo

0.00

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

## Quality Control

## Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*84355\***

Page 2

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 10/05/2012      **Start Qty:** 4.00

**\*4\***

**Cust Item ID:**

**Required Date: 24/05/2012      Req'd Qty: 4.00**

**\*4\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_      **Date:** \_\_\_\_\_      **Tooling:** \_\_\_\_\_      **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

Bend as per dwg

0.00

**\*130\***

Brake NC

## Memò

0.00

Brake NC

140

QC6- Inspect dimensions to drawing

0.00

**\*140\***

QC

## Memo

0.00

## Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

**\*150\***

### HandFinish

## Memo

0.00

## Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

May-10-12 11:26:27 AM

**\*84355\***

Page 3

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 10/05/2012    **Start Qty:** 4.00    **\*4\***

**Cust Item ID:**

**Required Date:** 24/05/2012      **Req'd Qty:** 4.00      **\* 1 \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

### Operation Description

### Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

160

QC7-Inspect Chemical Conversion Coat

0.00

**\*160\***

QC

## Memo

0.00

## Quality Control

170

Identify as per dwg & Stock Location: WA

0.00

**\*170\***

### Packaging

## Memo

0.00

## Packaging

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May-10-12 11:26:30 AM

Page 1

Work Order ID: 84355

\*84355\*

Parent Item: D4462-3

\*D4462-3\*

Parent Item Name: Baffle

Start Date: 10/05/2012

Required Date: 24/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.11.22 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.050		Purchased	No			100	sf	220.1640	2.564	10.79579			

\*M6061T6S 050\*

\*\*

6061-T6 .050 Sheet

Location

Loc Qty

Loc Code

021	144	
1211920	144	
MAT021	76.164	
114799	61.164	
114993	15	

1211920

Jm  
12-5-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	24355
<b>Description:</b> Baffle		<b>Part Number:</b>	D4462-3
<b>Inspection Dwg:</b> D4462	<b>Rev:</b> <del>A</del> B <del>M</del>	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
✓ <del>00.050</del> 0.50	+0.006/-0.001	0.504	✓		✓	HIB-02
✓ 00.768	+0.010/-0.001	0.771	✓		✓	HIB-02
✓ 03.50	+0.012/-0.001	3.503	✓		✓	HIB-02
✓ 0.70	+/-0.030	0.704	✓		✓	HIB-02
✓ 1.01	+/-0.030	1.009	✓		✓	HIB-02
<del>4.03</del> 4.49	+/-0.030	4.488	-		✓	HIB-02
<del>12.03</del> 11.88	+/-0.030	11.891	✓		✓	Prod-W-J-02
<del>18.12</del> 18.97	+/-0.030	18.97	✓		MT	HIB-01
<del>23.76</del> 23.62	+/-0.030	23.62	✓		MT	HIB-01
<del>24.46</del> 24.02	+/-0.030	24.02	-		MT	HIB-01
<del>24.47</del> 24.33	+/-0.030	24.33	✓		MT	HIB-01
<del>25.47</del> 25.02	+/-0.030	25.02	-		MT	HIB-01
1.38	+/-0.030	1.392	✓		MT	HIB-02
2.43	+/-0.030	2.427	✓		✓	HIB-02
3.38	+/-0.030	3.384	✓		✓	HIB-02
5.26	+/-0.030	5.26	✓		✓	HIB-02
7.13	+/-0.030	7.132	✓		✓	HIB-02
9.01	+/-0.030	9.006	✓		✓	Prod-W-J-02
9.94	+/-0.030	9.947	✓		✓	Prod-W-J-02
0.70	+/-0.010	0.699	✓		✓	HIB-02
1.95	+/-0.030	1.944	✓		✓	HIB-02
3.61	+/-0.030	3.600	✓		✓	HIB-02
4.70	+/-0.030	4.696	✓		✓	HIB-02
5.77	+/-0.030	5.777	✓		✓	HIB-02
7.45	+/-0.030	7.446	✓		✓	HIB-02
9.91	+/-0.030	9.911	✓		✓	Prod-W-J-02
10.20	+/-0.030	10.197	✓		✓	Prod-W-J-02
12.95	+/-0.030	12.95	✓		MT	HIB-01
<del>14.07</del> 14.49	+/-0.030	14.49	✓		MT	HIB-01
<del>20.24</del> 20.06	+/-0.030	20.06	✓		MT	HIB-01
✓ 0.050	+/-0.010	0.049	✓		✓	HIB-02

<b>Measured by:</b> JM	<b>Audited by:</b> M/mt	<b>Preliminary Approval:</b>
<b>Date:</b> 12-5-22	<b>Date:</b> 12-05-23	<b>Date:</b>

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	12.02.01	New Issue	KJ	

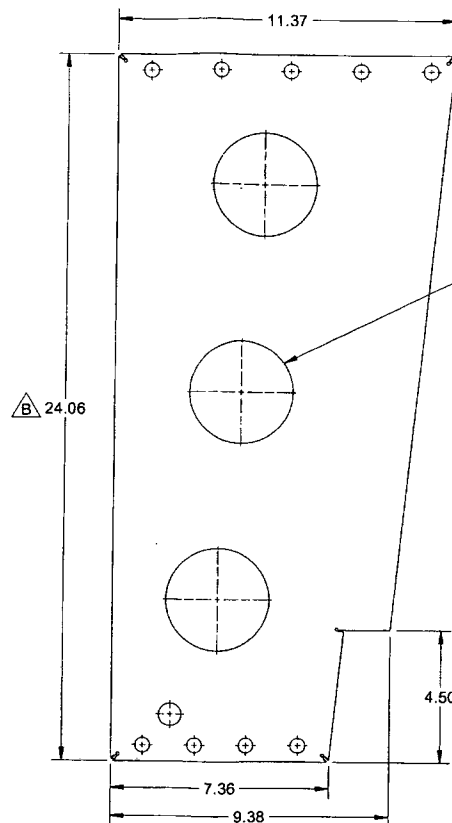
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



FLANGE IN SAME DIRECTION  
AS BENDS USING DT9776  
3 PL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER

NO. 84355 MLT

12/05/10

RELEASED  
2012-03-02

# **D4462-1 BAFFLE**

## **NOTES:**

- 1) MATERIAL: MADE FROM D4462-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.12 lbs
- 8) BEND ANGLE: 90° +/- 5°

B	D4462-1 HEIGHT WAS 24.21, IS NOW 24.06 (ZN C5-1). D4462-3 HEIGHT WAS 24.25, IS NOW 24.11 (ZN C5-3). TAB LENGTH WAS 0.70, IS NOW 0.80 (ZN D1-2/4). ADDED NOTE 8 (ZN A8-1/3).	DC	11.12.05
A	NEW ISSUE	DC	11.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	DC		
CHECKED	DC		
MFG. APPR.	DC		
APPROVED	MD		
DE APPR.			
DATE	11.12.05		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

**D4462**

REV. B

SHEET 1 OF 4

TITLE

**BAFFLE**

SCALE

NTS

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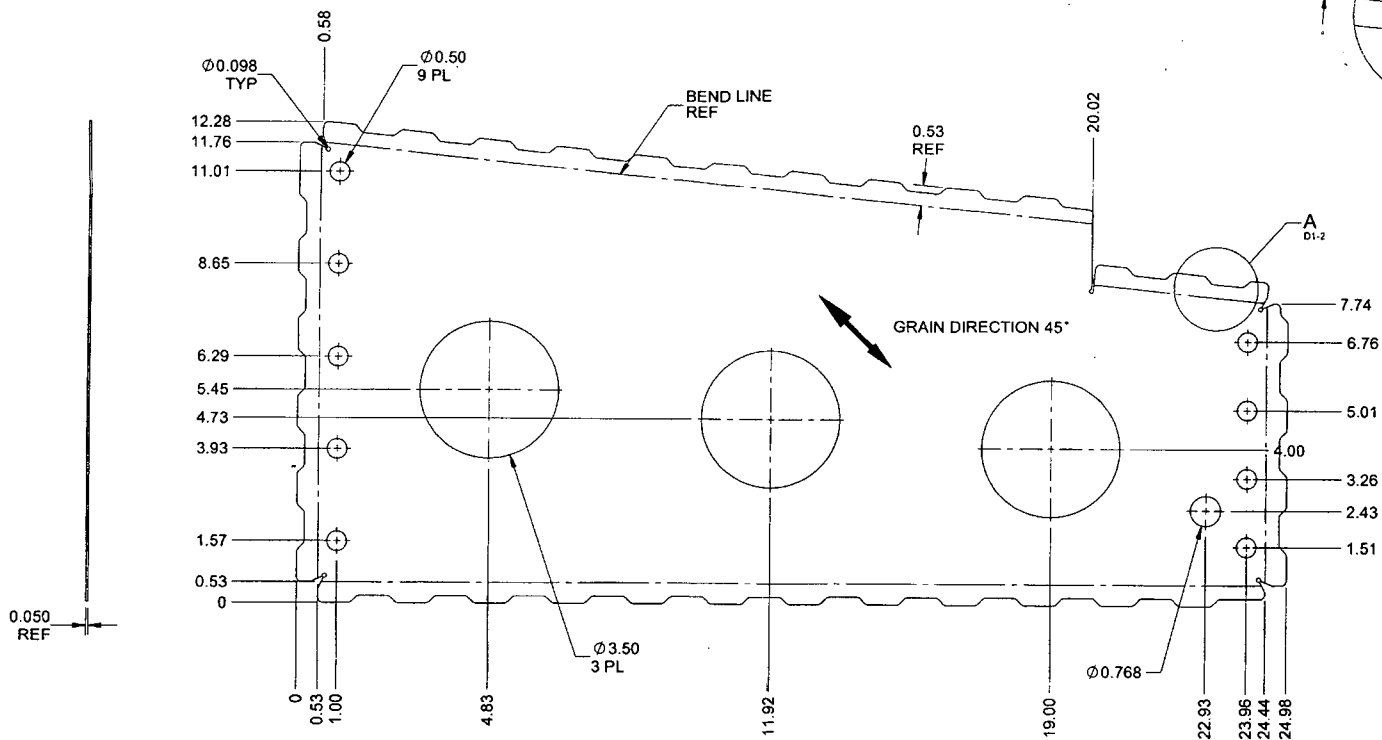
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4462-1F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.050
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.12 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D4462</b>	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>BAFFLE</b>	NTS
DATE	11.12.05	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

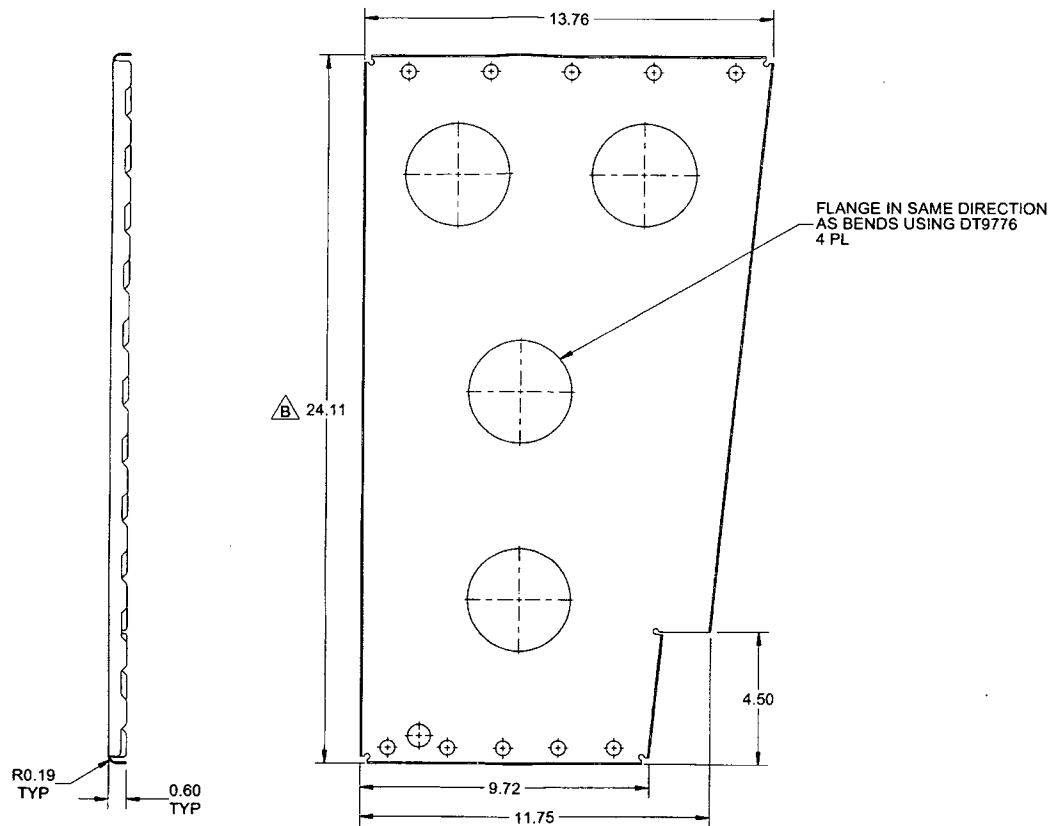
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4462-3 BAFFLE**

**NOTES:**

- 1) MATERIAL: MADE FROM D4462-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.36 lbs
- 8) BEND ANGLE: 90° +/- 5°

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4462	SHEET 3 OF 4
APPROVED		TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

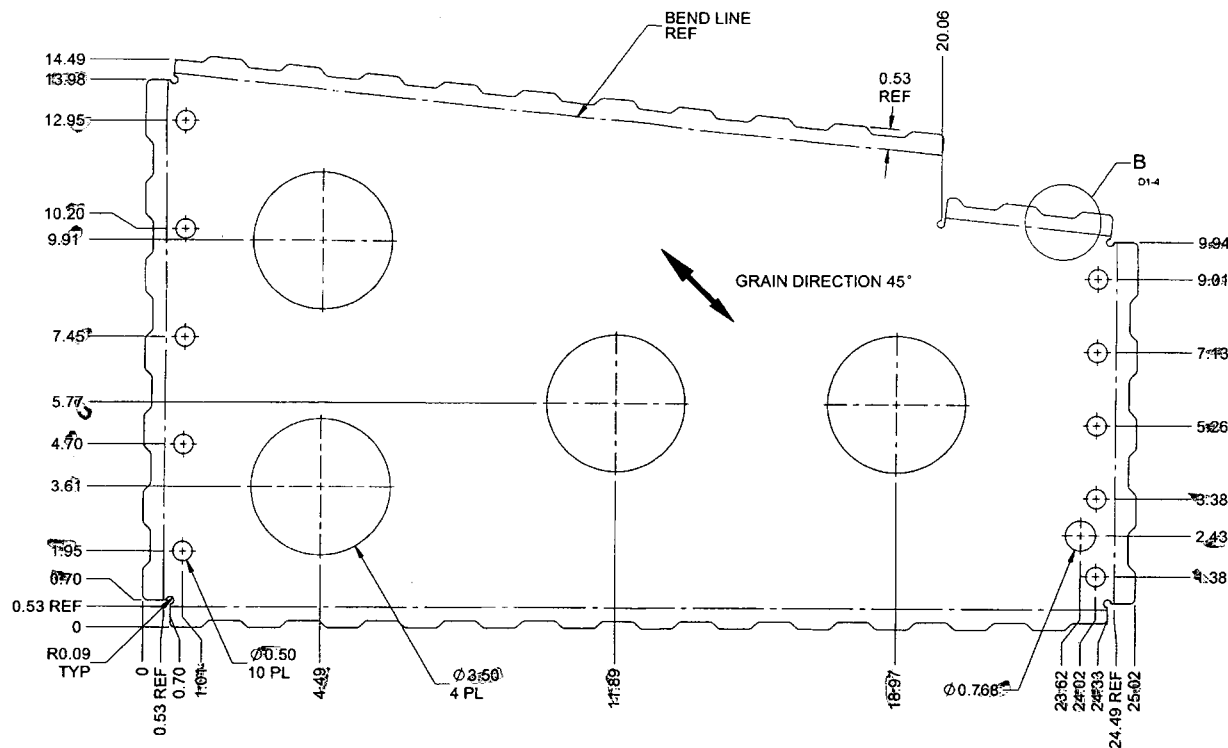
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



0.050  
REF



**DETAIL B**  
SCALE: 2X  
C3-4

84355

RELEASED  
2012-03-03  
WIP

# **D4462-3F FLAT PATTERN**

## **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.050
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.36 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D4462</b>	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>BAFFLE</b>	NTS
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